

Date: Monday, 12/11/2006 12:54:06 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: END CAP	
Job Number	: 29849		Part Number	: D28502	
Estimate Number	: 11675		Drawing Number	: D28502 REV A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 12/11/2006 S.O. No. : 11675		Drawing Revision	: A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 1/20/2007	
Previous Run	: N/A		Qty:	20	
Written By			Um:	Each	
Checked & Approved By					
Comment	: Est. B 08.12.07 Changed folio DM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B2500X01500	6061-T6 Bar 2.5" x 1.5"
Comment: Qty.: 0.3368 f(s)/Unit Total : 6.7368 f(s)		M100947X2.3576 f(s)
6061-T6 Bar 2.5" x 1.5"		
6061-T6 2.5" X 1.5"		Batch M9877X4.3784 f(s)
2.0	SHEAR	SHEAR
Comment: SHEAR Shear blanks: 3.8"		J.L 07/01/03
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Machine per Folio D2850-2 Deburr and Tumble		J.L/J.F. 07/01/04
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		J.L/J.F. 07/01/04
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 57389		7/01/05 (20)
4/1/07 04:05 Q88		Second Check: 5/1 07.04.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/01/08
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: END CAP

Job Number: 29849

Part Number: D28502

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



do

Comment: FINAL INSPECTION/W/O RELEASE

SD07/11/08

Job Completion



u 07/11/08

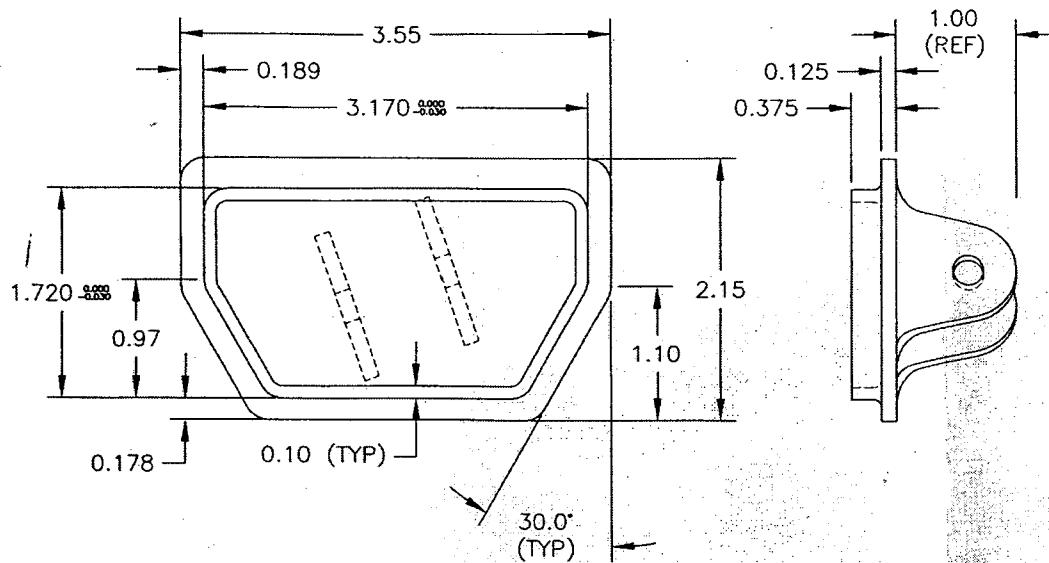
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



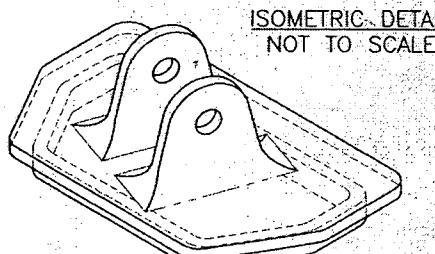
D2850-1 (SHOWN)
D2850-2 (OPPOSITE)

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)

FINISH: NONE

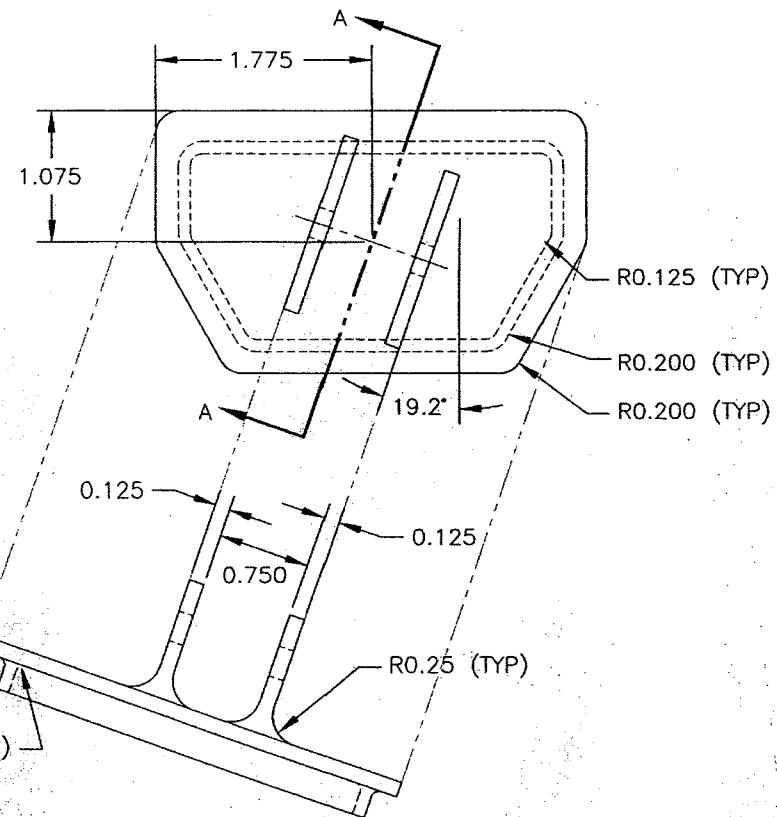
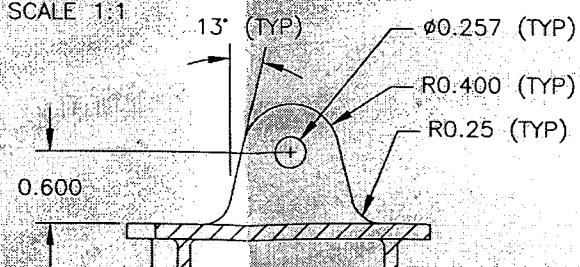
BREAK ALL SHARP EDGES 0.010 TO 0.020

TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED



ISOMETRIC DETAIL
NOT TO SCALE
NO. 29849
WORK ORDER
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

SECTION A-A
SCALE 1:1



RELEASED 45.11.25 KF

A	98.11.10	NEW ISSUE, REPLACES D2357 REV. A AND D2358 REV. B
DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED HF	DRAWING NO. D2850
DATE		REV. A
98.11.10		SHEET 1 OF 1
		SCALE 1:1
		TITLE HIGH FLOAT STEP END BRACKET

DART AEROSPACE LTD	Work Order:	29849
Description: end cap	Part Number:	D 2850-2
Inspection Dwg: A2850 , Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	JL	Audited by:	ml	Prototype Approval:	
Date:	07/01/03	Date:	07/01/03	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	